

VISIT...

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- THE THOMPSON SUBMACHINEGUN
MODEL M1A1
MACHINIST'S WORKING DRAWINGS
IN FOUR PLATES

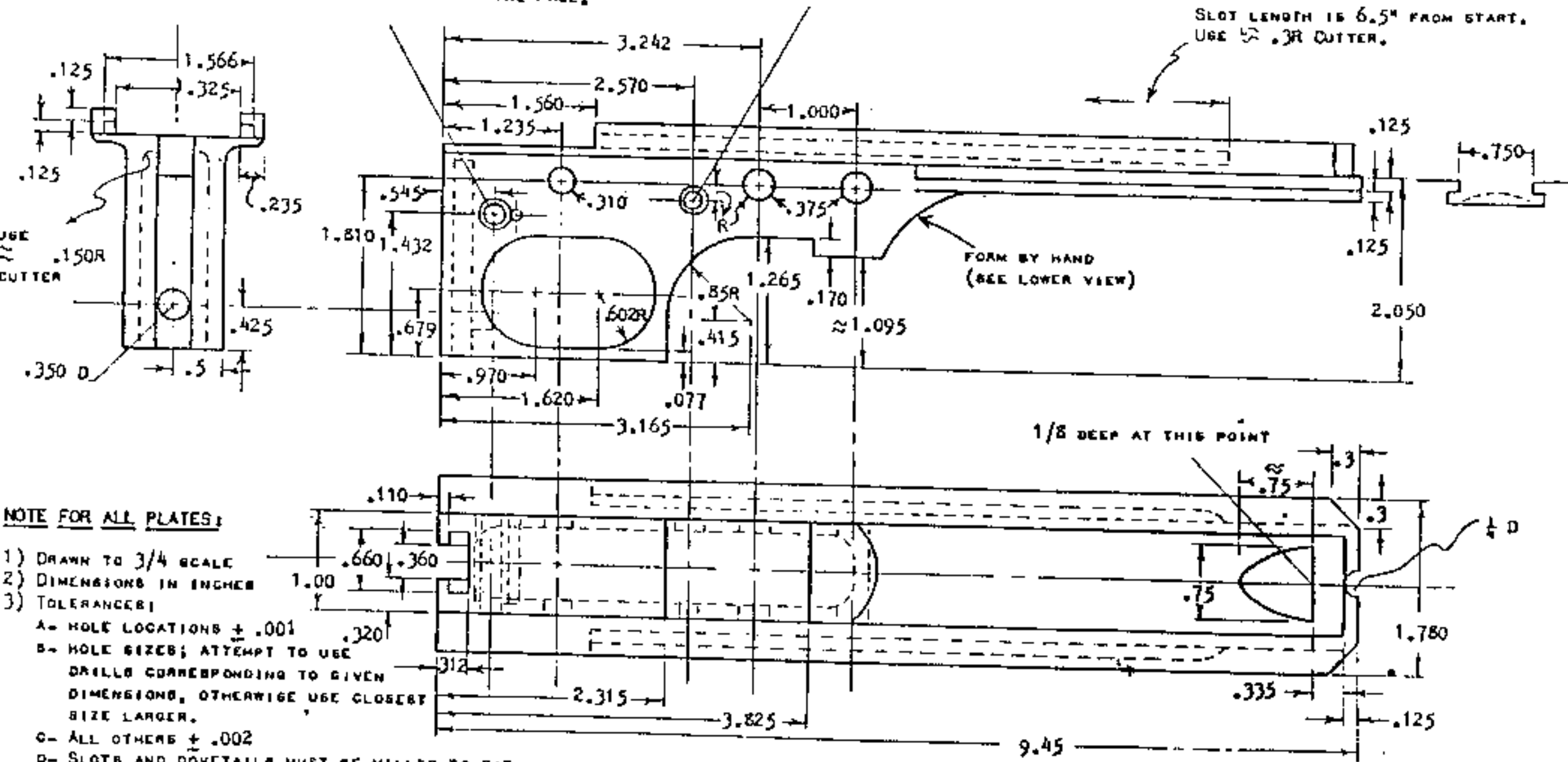
P L A T E O N E

-TRIGGER HOUSING-

CENTER HOLE IS .250 D AND GOES ALL THE WAY THROUGH. LARGEST IS .380 D, SMALLEST IS .150 D; BOTH GO TO A DEPTH OF .675. SMALLEST INTERSECTS AS SHOWN AND LEAVES A SLOT BETWEEN 22 .075 WIDE. THE SMALLEST SHOULD BE LOCATED .610 FROM THE FACE.

CENTER HOLE IS .185 Ø AND IS DRILLED FIRST, ALL THE WAY THROUGH. SECOND HOLE IS .300 Ø, AND IS DRILLED ONLY THROUGH THE FIRST WALL.

SLOT LENGTH IS 6.5" FROM START.
USE 1/2" .3R CUTTER.

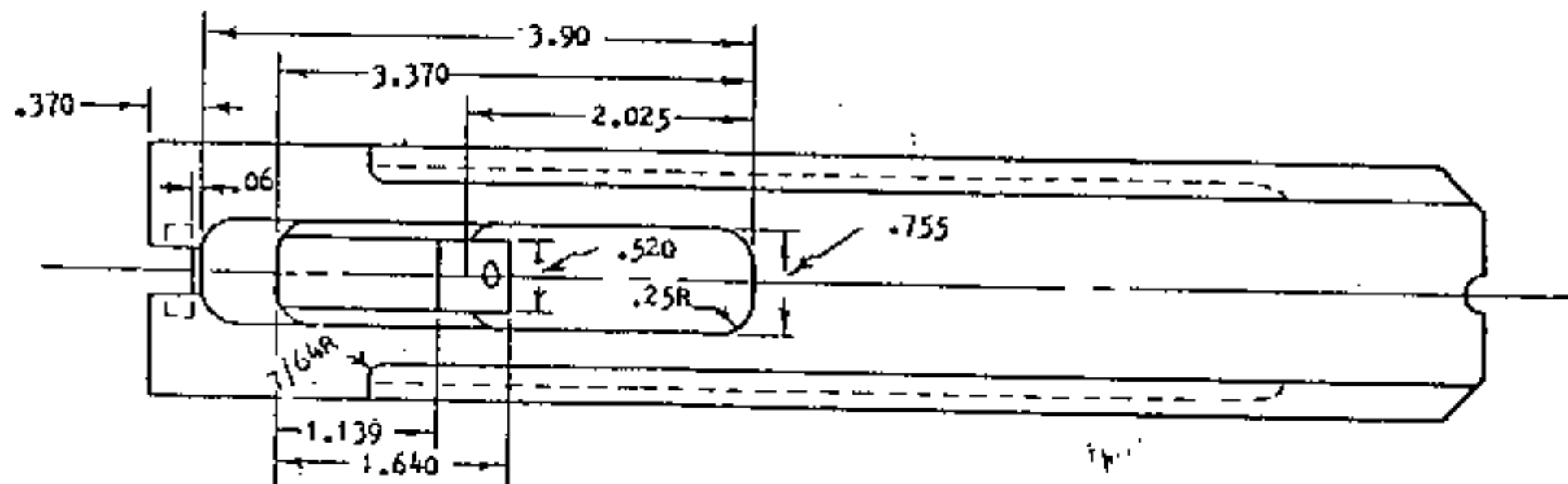
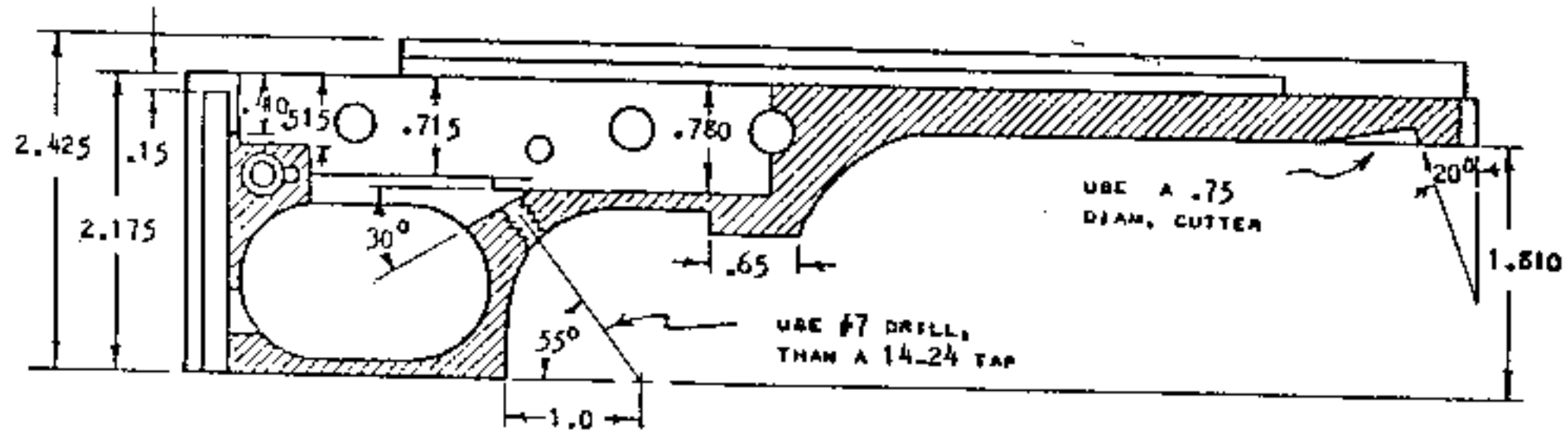


NOTE FOR ALL PLATES:

- 1) DRAWN TO 3/4 SCALE
- 2) DIMENSIONS IN INCHES
- 3) TOLERANCES:
- A- HOLE LOCATIONS $\pm .001$
- B- HOLE SIZES; ATTEMPT TO USE
DRILLS CORRESPONDING TO GIVEN
DIMENSIONS, OTHERWISE USE CLOSEST
SIZE LARGER.
- C- ALL OTHERS $\pm .002$
- D- SLOTS AND DOVETAILS MUST BE MILLED TO FIT.
- 4) FILLETS AND ROUNDS 1/8R UNLESS INDICATED.

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PLATE TWO
-TRIGGER HOUSING-
(ALTERED TO TAKE
M1928 BUTT-STOCK)

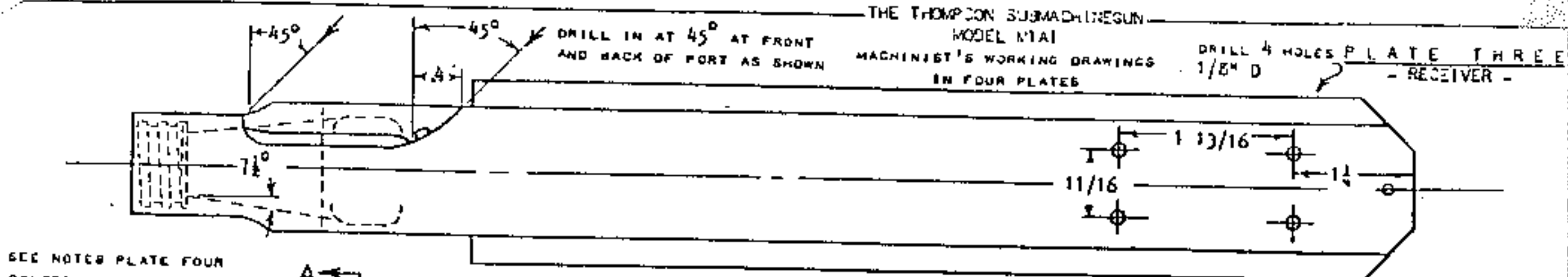


THE THOMPSON SUBMACHINEGUN

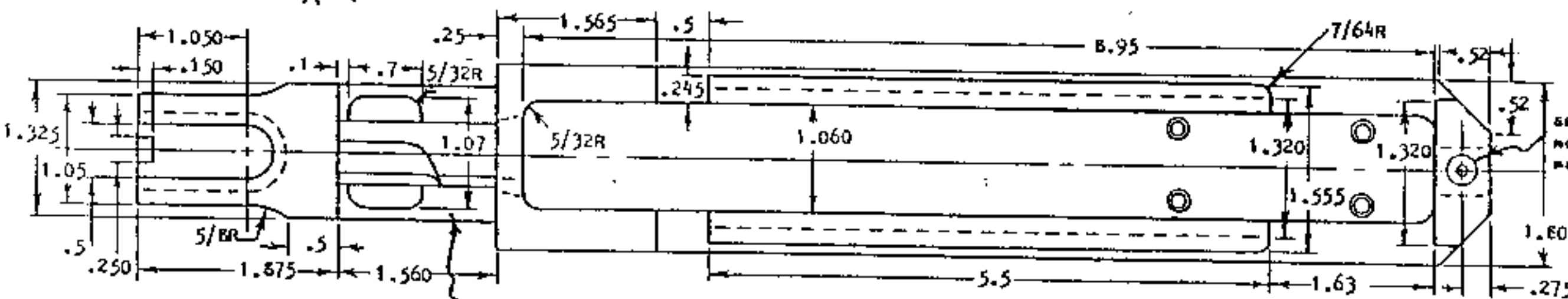
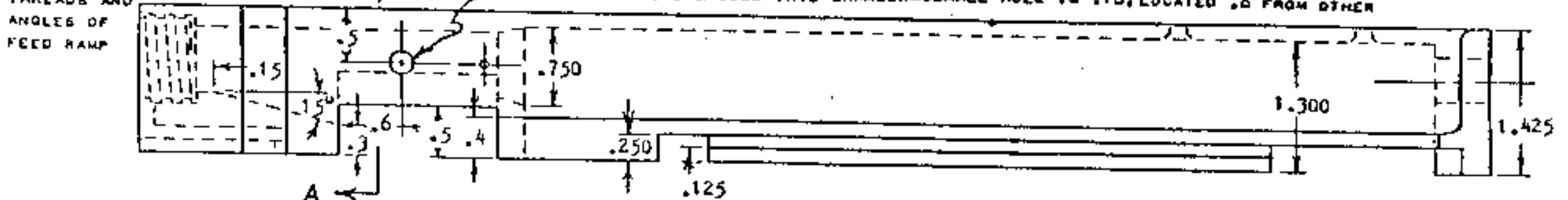
MODEL M1A1

MACHINIST'S WORKING DRAWINGS
IN FOUR PLATES

DRILL 4 HOLES PLATE THREE
1/8" D - RECEIVER -

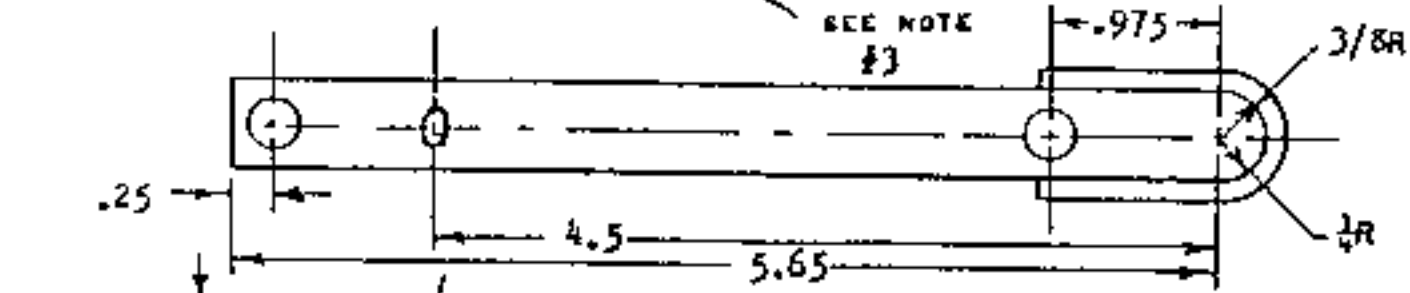


LARGE HOLE IS .20 & GOES INTO CHAMBER--SMALL HOLE IS .10; LOCATED .6 FROM OTHER

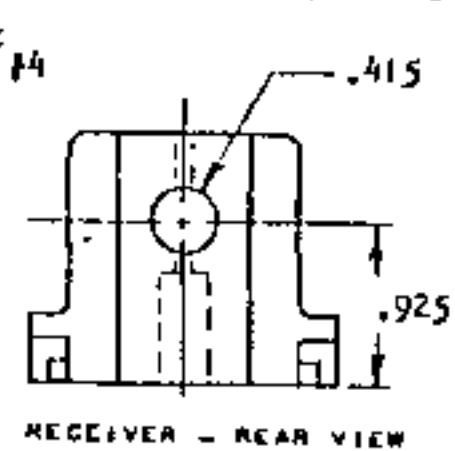
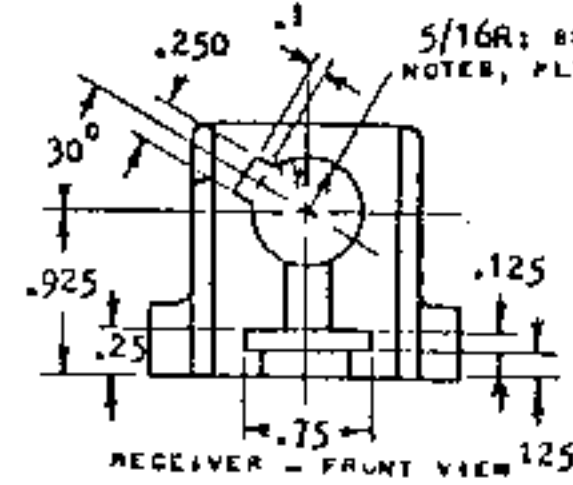


SEE NOTE #2
PLATE 4

SEE NOTE #3



USE #7 DRILL & 14-24 TAP
FOREGRIP PLATE:
SEE NOTES PLATE FOUR



THE THOMPSON SUBMACHINEGUN
MODEL M1A1
MACHINIST'S WORKING DRAWINGS
IN FOUR PLATES

PLATE FOUR

1. ON ALL PLATES: MANY HIDDEN LINES HAVE BEEN ELIMINATED TO SIMPLIFY VIEWS - ONLY NECESSARY HIDDEN LINES ARE SHOWN.

2. DRILL $3/23$ LOCATING HOLE FROM TOP, THEN DRILL $.300$ HOLE FROM BOTTOM TO A DEPTH OF $.620$ (SEE REAR VIEW).

NOTES:

3. THESE TWO SURFACES ARE CUT AT 45° (SEE SEC. "A-A")

4. TWO $.3$ DIAM. ROUND BARS ARE HEAT-FITTED INTO PLATE AND THEN CUT AS SHOWN, THE FRONT ONE CUT TO FIT BARREL - THE REAR ONE CUT TO FIT SLOT IN FRONT OF RECEIVER.

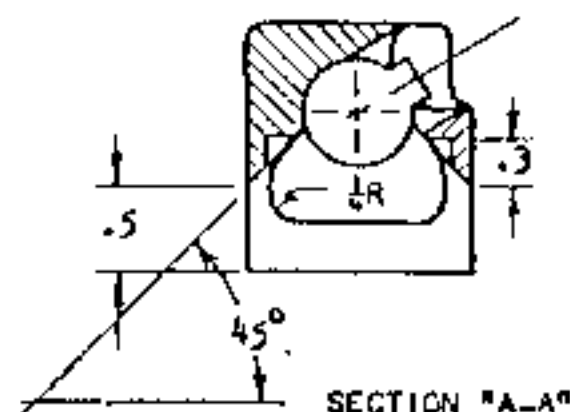
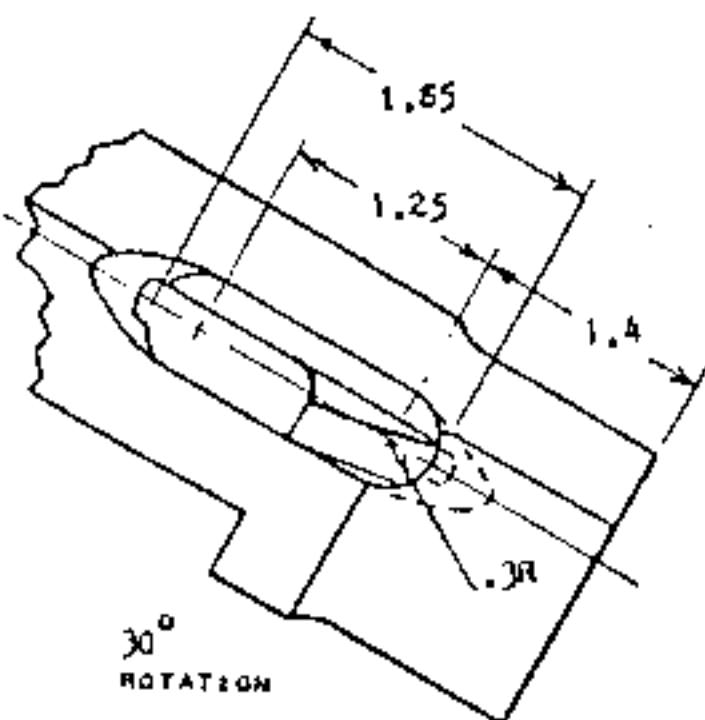
5. A $5/8$ DIAM. HOLE AND SLOT ARE CUT INTO THE RECEIVER BEFORE THREADS ARE CUT (SEE FRONT VIEW), BOTH GO TO DEPTH OF 3.685 .

6. RECEIVER THREADS ARE SQUARE THREADS, 13 TPI, $.850$ MD AND $.750$ MIN D, DEPTH TO $.55$.

7. THE FLOOR OF THE FEED RAMP IS INCLINED 15° AND STARTS $.15$ INCHES FROM CHAMBER. THE SIDES OF THE RAMP SLOPE 7.5° TO EITHER SIDE AND START FROM THE EDGE OF THE CHAMBER WHILE STILL AT 15° FROM THE HORIZONTAL. USE A $1/2$ " DIAMETER CUTTER.

8. BARREL AND RECEIVER MUST BE HEAT-FITTED.

9. USE 4130 CHROME' STEEL FOR RECEIVER



SECTION "A-A"

